

Date: Tuesday, 8/1/2006 11:31:23 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OUTER FWD SADDLE
 Job Number : 28079
 Estimate Number : 11076
 P.O. Number : N/A Part Number : D5951
 This Issue : 8/1/2006 S.O. No. : N/A Drawing Number : D5951 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : N/A Material : N/A
 Due Date : 8/31/2006 Qty: 4 Um: Each
 Written By : KA 06-08-01
 Checked & Approved By : KA 06-08-01
 Comment : Est Rev:E Re-Format 05-11-29 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101013 Saddle billet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

D6101-013 (7075-T7351)

Size 2.50" x 10.10" X 8.25" (Grain along 10.10")

Batch: ~~325356~~ 325356 x 4 En 06/11/03

2.0 HAAS3 HAAS CNC VERTICAL MACHINING #3



Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5951, Ensure Batch Number is entered

328079

2-Machine Keyway P70

3-Deburr & Tumble

5.6 / En 06/11/03 4

3.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

5.6 / En 06/11/03 4

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 06.11.06 (4)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

am yd 06/11/08 x 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06.11.03	2	CHAMFER 0.033 x 45° WAS ADDED AND CALLED Ⓟ. SIMILAR TO D2571. SEE ATTACHED	PH 06.11.03				<i>RE</i> 06.11.03

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *PH* Date: 06/11/13

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/1/2006 11:31:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER FWD SADDLE

Job Number: 28079

Part Number: D5951

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 11 11 (4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 6/11/13 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 6/11/13 (4)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/11/13 (4)

Job Completion



C 20611113

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	28079
Description: Outer Fwd Saddle	Part Number:	D5951
Inspection Dwg: D5951 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5951 Rev. A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.747	1.747	1.747		
C	5.245	5.255		5.249	5.250	5.240	5.248		
D	6.995	7.005		7.002	7.001	7.000	7.002		
E	5.745	5.755		5.751	5.748	5.751	5.751		
F	4.745	4.755		4.746	4.747	4.746	4.746		
G	0.313	0.318	DT8686	0.315	0.315	0.315	0.315		
H	1.522	1.532		1.527	1.524	1.526	1.529		
I	3.048	3.058		3.052	3.054	3.054	3.053		
J	4.575	4.585		4.577	4.580	4.581	4.581		
K	0.313	0.318	DT8686	0.315	0.315	0.315	0.315		
L	0.240	0.260		0.256	0.251	0.256	0.257		
M	0.490	0.510		0.505	0.503	0.504	0.505		
N	0.240	0.260		0.255	0.251	0.256	0.257		
O	7.990	8.010		8.001	8.006	8.003	8.005		
P	0.240	0.260		0.259	0.256	0.255	0.257		
Q	0.307	0.312		0.309	0.310	0.311	0.311		
R	0.760	0.765		0.765	0.765	0.765	0.765		
S	0.490	0.510		0.491	0.500	0.504	0.503		
T	1.375	1.395		1.383	1.385	1.384	1.385		
U	2.000	2.020		2.003	2.003	2.004	2.004		
V	0.023	0.043		0.030	0.030	0.030	0.030		
W	0.023	0.043							
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

PH 05-11-03

Measured by: <u>Er / S.G</u>
Date: <u>06/10/03</u>

Audited by: <u>SD</u>
Date: <u>06.11.06</u>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	

DART

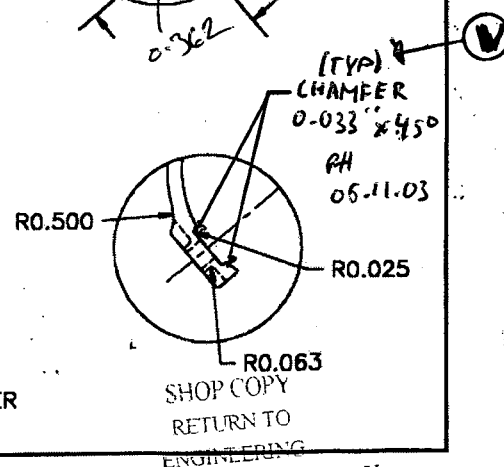
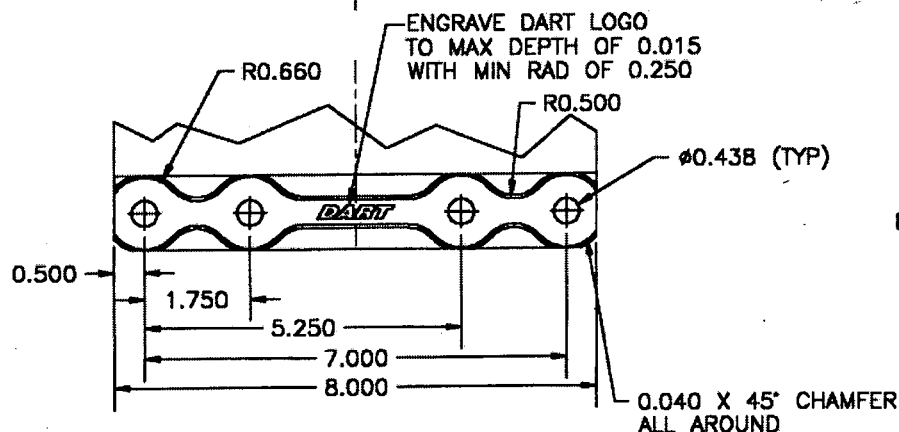
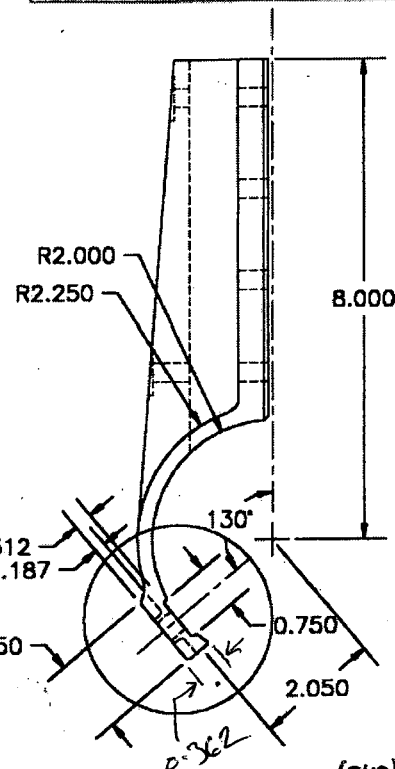
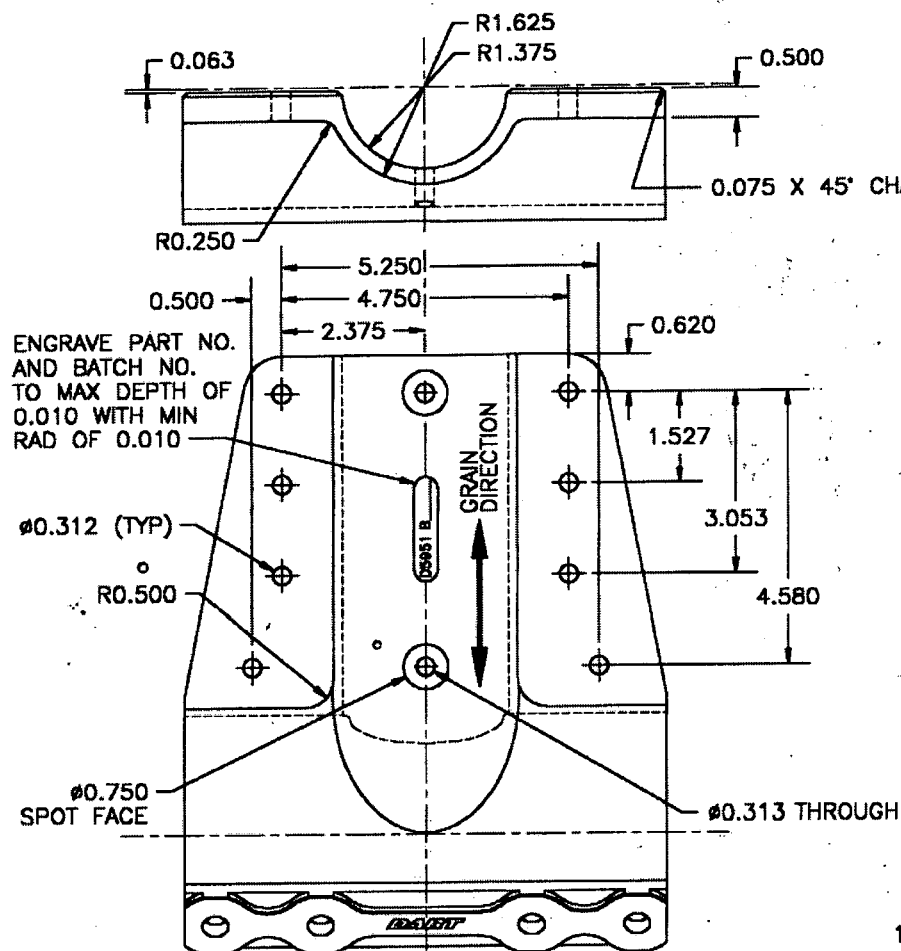
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED BW	DRAWING NO. D5951	REV. A SHEET 1 OF 1
DATE 97.05.06	TITLE OUTER FWD SADDLE		SCALE

MATERIAL: ~~7075-T651~~ OR 7075-T7351 QQ-A-250/12
FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
PRIME, PAINT HI GLOSS WHITE (EXCEPT BORES) PER QSI 005 4.2
BREAK ALL SHARP EDGES 0.010 TO 0.020

RELEASED
97/05/14 DS

EFFECTIVE DEOs

9102 98/05/04 DS	9679 98/06/22 DS
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WITHOUT NOTICE
WORK ORDER
NO. 28079

Peter Hum

From: David Shepherd [dshepherd@dartaero.com]
Sent: November 3, 2006 10:22 AM
To: 'Peter Hum'
Subject: RE: D5951/D5953/D5955/D5957

This change is acceptable to me.

David

From: Peter Hum [mailto:phum@dartaero.com]
Sent: Thursday, November 02, 2006 2:33 PM
To: 'David Shepherd'
Subject: D5951/D5953/D5955/D5957

David,

Last year we made a change to the ridges on the 205 saddles (we made a 0.033" X 45 degree chamfer) which I've attached.

Production is making a run of the extended high gear saddles D5951/D5953/D5955/D5957. Can the changes made to the 205 saddles be applied to the x-tended high gear saddles?

The extended high gear goes onto the same D205-634 skidtubes

Chris Bell is currently updating the D5951/D5953/D5955/D5957 saddles and if this change is acceptable, we will add it in

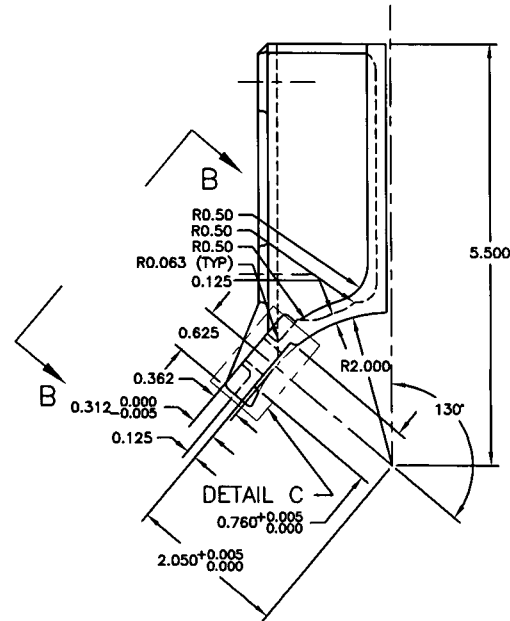
Peter

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Checked by AVG Free Edition.
Version: 7.1.409 / Virus Database: 268.13.23/513 - Release Date: 11/2/2006

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No virus found in this outgoing message.
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Version: 7.1.409 / Virus Database: 268.13.23/513 - Release Date: 11/2/2006

03/11/2006

REFERENCE ONLY

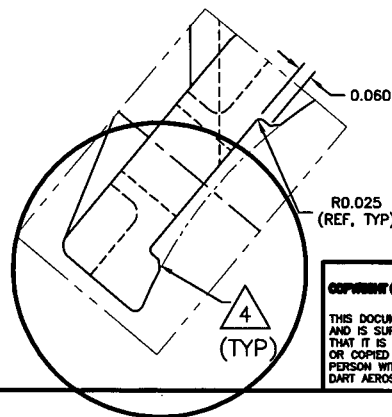


NOTES

MATERIAL: 7075-T7351 (Q0-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

REFERENCE ONLY



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E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCPOR. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	APPROVED	DART DART AEROSPACE LTD. MISSISSAUGA, ONTARIO, CANADA
DATE	05.07.13	DRAWING NO. D2574
		TITLE INNER AFT SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3